

Date: Wednesday, 25/06/2008 11:59:52 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)	
Job Number :	40085	Part Number :	D2572	
Estimate Number :	10531	Drawing Number :	D2572 REV E	
P.O. Number :		Project Number :	N/A	
This Issue :	25/06/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	E	
First Issue :	/ /	Type :	MACHINED PARTS	
Previous Run :	39807	Material :		
Written By :		Due Date :	07/07/2008	Qty: 12 Um: Each
Checked & Approved By :	<u>JUL 08-6-25</u>			
Comment :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101005	Saddle Billet
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: B34874

ML 08/07/15

(12)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 40085 Double check by: DJP

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove shap edges.

ML / J.L 08/02/15

(12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572



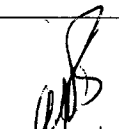


ML / J.L 08/02/15

(12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2572 PAR #: N/A Fault Category: Prod/Machines Parts NCR: (Yes) No DQA: D Date: 08/07/16
D412-742 QA: N/C Closed: D Date: 08/07/16

NCR: 40085		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.07.07	3	Xtube bore wall is 0.103" ON ONE SIDE. R.C. operator error	 08.07.07 PL 05/07/07	SCRAP 96E.07.07 Destroy and Replac Qty 1 B# 34874	 08/07/07	S	 08/07/07	 08/07/07
		on taking origin on Second opp.	 08/07/07					

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 11:59:53 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 40085

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf / J.L 08/07/15 (12)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Sodalis (12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ELK 08/07/15

08/07/15 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 1:30pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:00pm

08-07-15

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M.A. 08/07/16

08/07/16 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/07/16 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/16

Job Completion



mf 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 40085
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

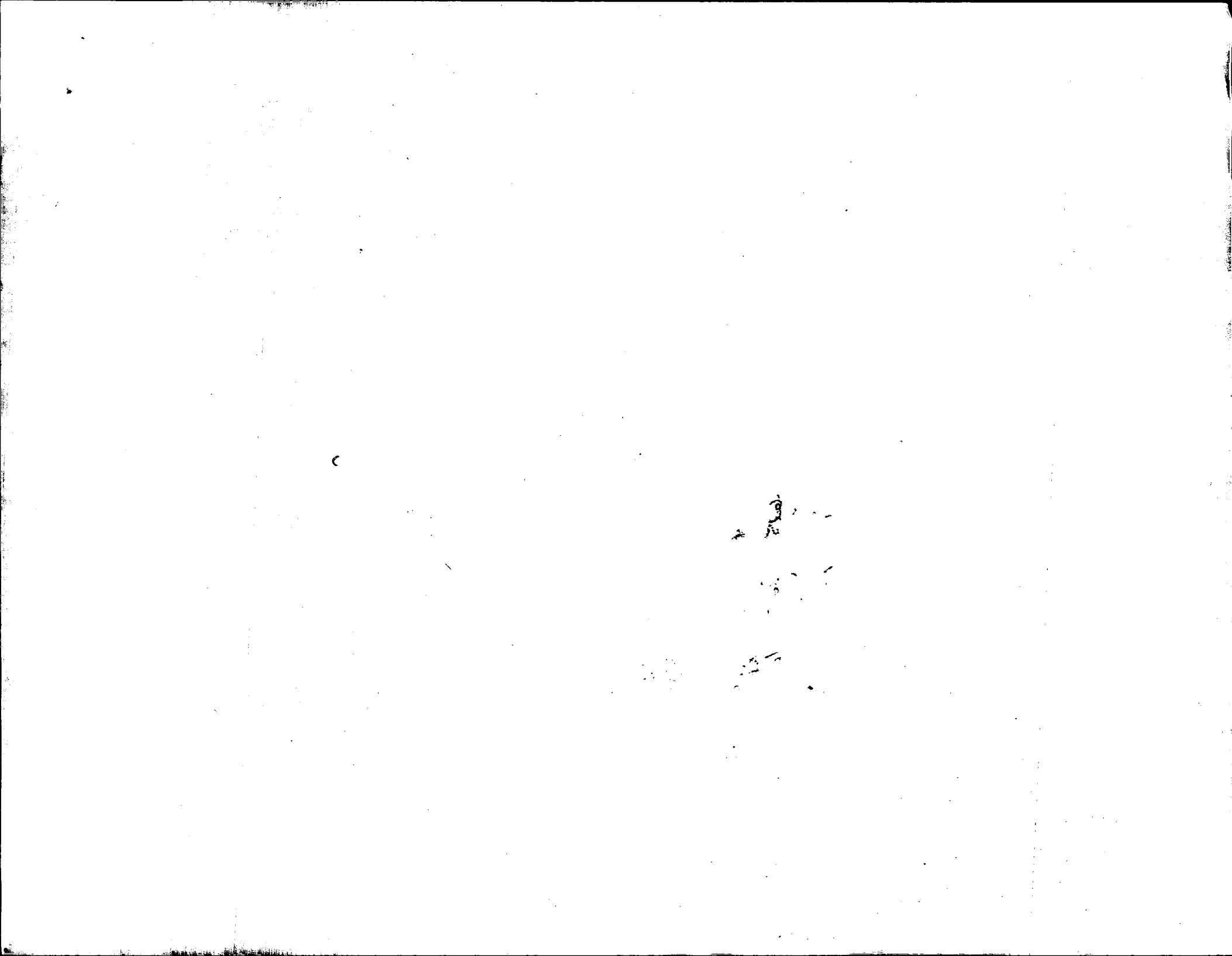
Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	7.999		
F	0.490	0.510		.499	.500	.499	.506		
G	0.257	0.262		.260	.258	.258	.258		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.502	.504	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.570	.569	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.124	.122	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.247	.249	.248	.248		
S	0.115	0.135		.130	.126	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.238	.238	.238		
W	0.115	0.135		.126	.127	.130	.131		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.761		
Z	0.352	0.372		.364	.364	.365	.365		
AA	0.470	0.530		.506	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.247	.248	.247		
AE	1.375	1.395		1.385	1.386	1.388	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.249	.248	.250		
AI	2.000	2.020		2.005	2.003	2.004	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>ML / JI</i>
Date: 08/07/08

Audited by: <i>S</i>
Date: 08/24/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

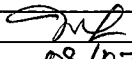


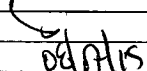
DART AEROSPACE LTD	Work Order: 40085
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1



Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	7.998		
F	0.490	0.510		.504	.509	.504	.505		
G	0.257	0.262		.258	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.500	.500	.500	.501		
J	1.174	1.184		1.180	1.178	1.178	1.178		
K	0.558	0.578		.569	.568	.569	.570		
L	1.174	1.184		1.180	1.178	1.178	1.178		
M	1.490	1.500		1.499	1.496	1.494	1.495		
N	2.495	2.505		2.506	2.500	2.506	2.500		
O	3.869	3.879		3.871	3.871	3.871	3.872		
P	0.115	0.135		.128	.128	.127	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.250	.250		
S	0.115	0.135		.128	.128	.127	.129		
T	0.178	0.198		.188	.188	.188	.189		
U	2.940	2.980		2.966	2.958	2.966	2.960		
V	0.230	0.250		.234	.234	.235	.235		
W	0.115	0.135		.130	.130	.132	.129		
X	0.307	0.312		.308	.308	.308	.308		
Y	0.760	0.765		.766	.760	.760	.761		
Z	0.352	0.372		.364	.361	.364	.364		
AA	0.470	0.530		.500	.500	.506	.506		
AB	0.615	0.635		.629	.629	.628	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.247	.248		
AE	1.375	1.395		1.388	1.390	1.387	1.386		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.248	.250	.250		
AI	2.000	2.020		2.004	2.008	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: 
Date: 08/07/10

Audited by: 
Date: 08/07/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM 	

DART AEROSPACE LTD	Work Order: 40085
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

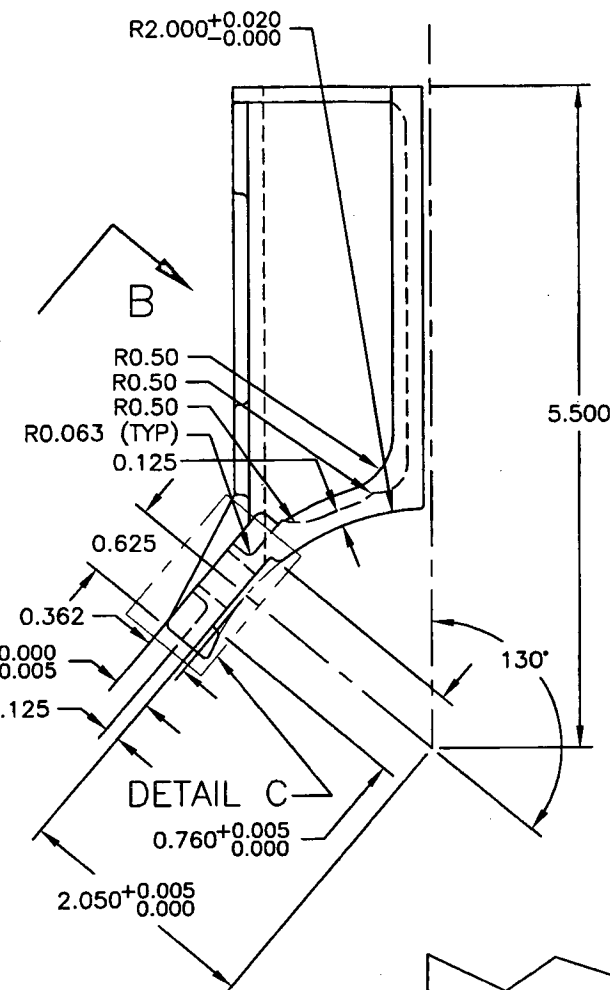
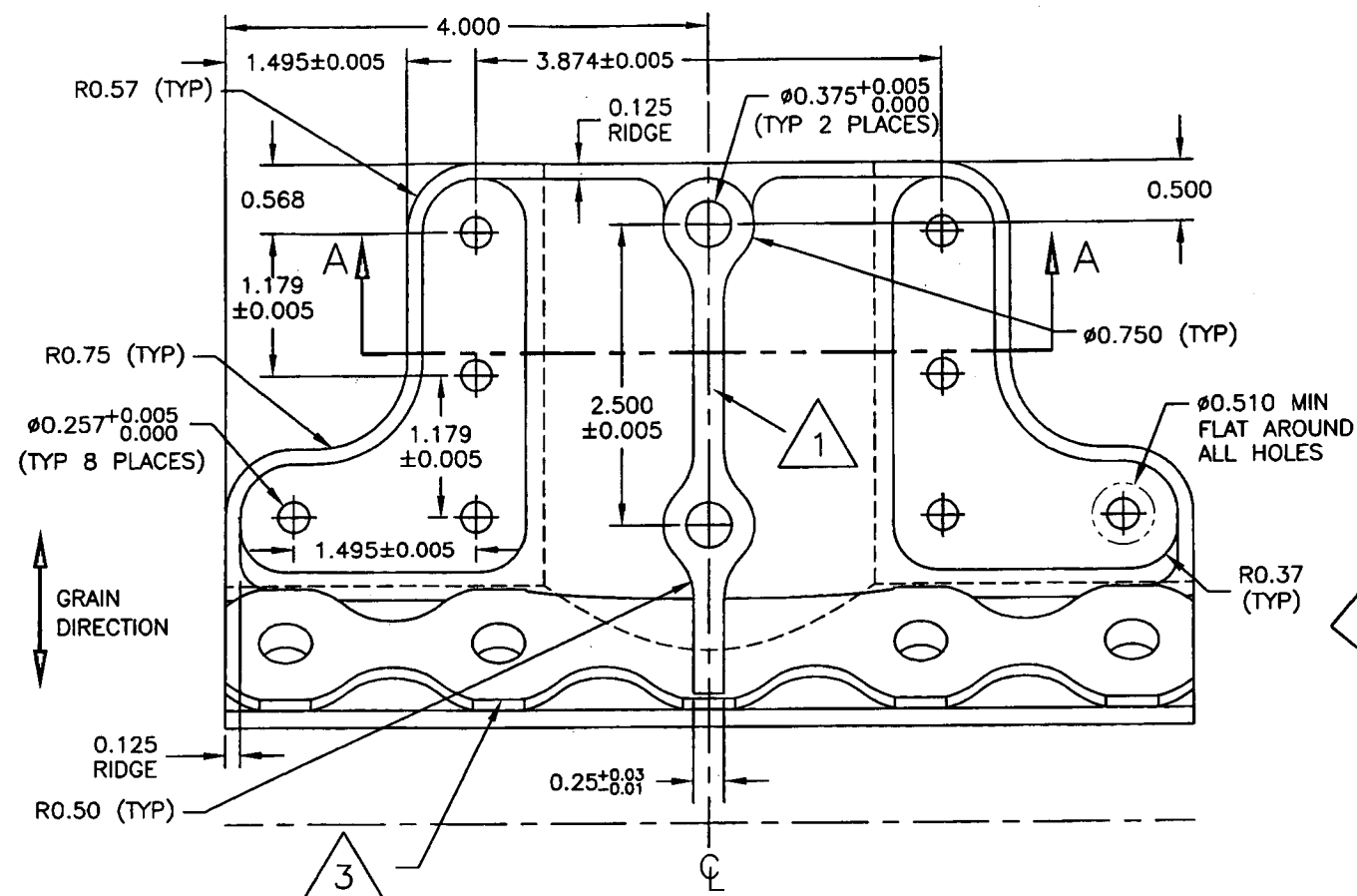
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	7.998		
F	0.490	0.510		.503	.504	.503	.502		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.500	.500	.501	.500		
J	1.174	1.184		1.177	1.178	1.179	1.179		
K	0.558	0.578		.568	.567	.570	.568		
L	1.174	1.184		1.177	1.178	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.494	1.495		
N	2.495	2.505		2.500	2.499	2.498	2.500		
O	3.869	3.879		3.871	3.872	3.870	3.872		
P	0.115	0.135		.127	.127	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.129	.130	.128	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.966	2.960		
V	0.230	0.250		.235	.236	.238	.236		
W	0.115	0.135		.131	.132	.131	.131		
X	0.307	0.312		.308	.308	.307	.308		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.364	.355	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.248	.248	.247		
AE	1.375	1.395		1.388	1.387	1.386	1.386		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.250	.250	.250		
AI	2.000	2.020		2.004	2.005	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>gml</i>	Audited by: <i>S. edr/15</i>
Date: 08/07/11	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

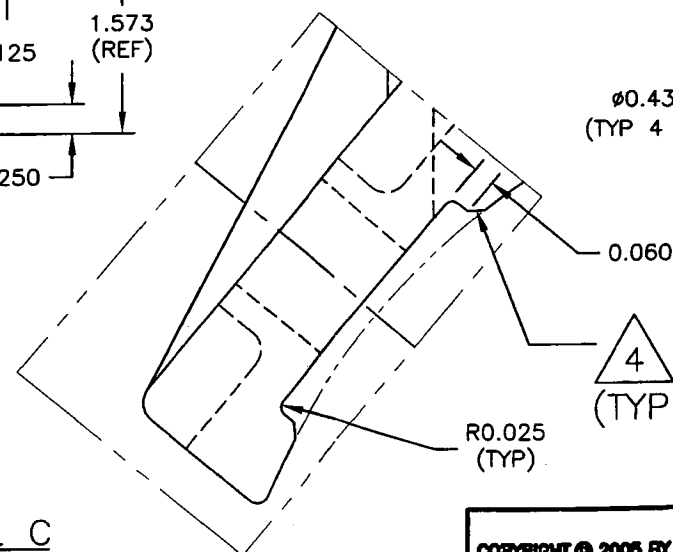
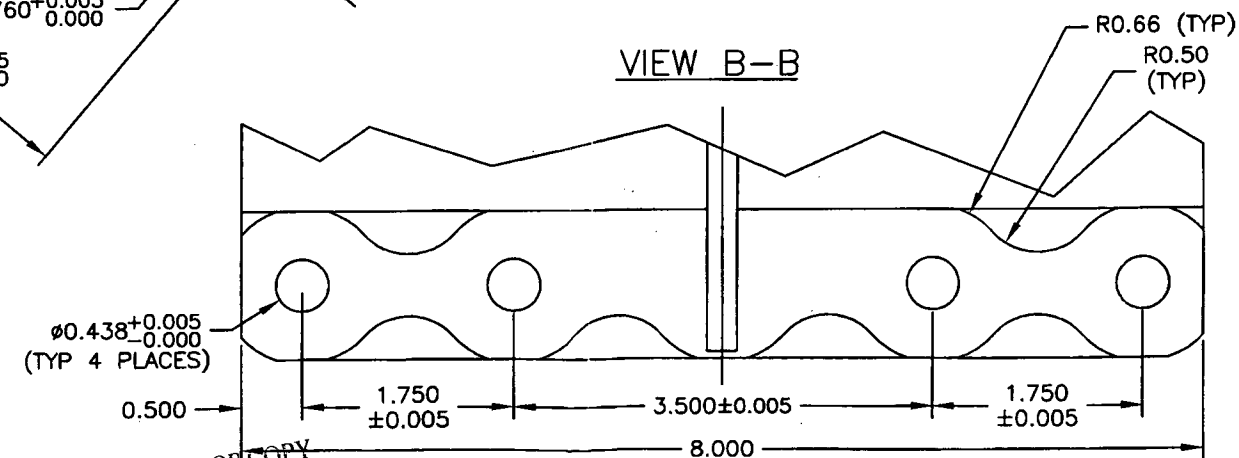
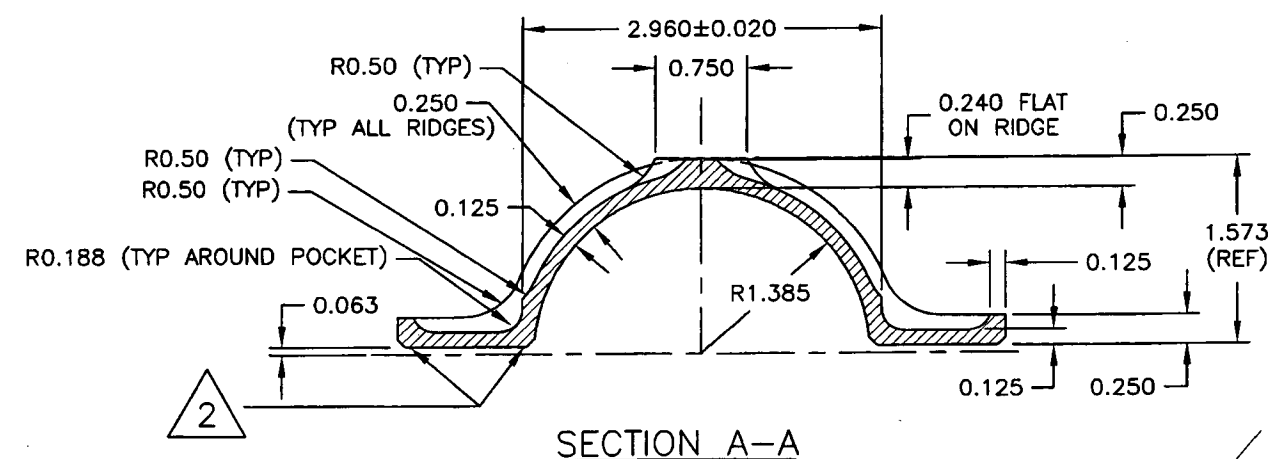
05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



DETAIL C
SCALE 2:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40085

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2572	REV. E SHEET 1 OF 1
DATE 05.07.13	TITLE INNER FWD SADDLE	SCALE 2:3	

